

Technical Data Sheet.



Permafleet® HS Top Coat 670.

Permafleet® HS Top Coat 670 is a high-grade, VOC-compliant High Solid 2K top coat system for solid colours.

Field of application: Partial resprays and full refinishes for commercial vehicles and buses.

Features:

- reliable application
- very good hiding power
- low material consumption
- fast drying
- high-gloss finish
- very good resistance

The range of colours includes all European CV and standard colours as well as many fleet colours.

All solid colours can be mixed lead-free with the compact mixing system.

For professional use only!

CV Technical Data Sheet No. EN / 0670 / 03

Substrate.

Suitable substrates:

1. Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork.
2. Surfaces coated with a primer or a surfacer.

Suitable priming materials:

Depends on the object and on the substrate, in accordance with our system recommendation.

Substrate pretreatment:



Clean all substrates carefully with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.



Sand dry with random orbital sander and dust extraction, P400 – 500 grade

or



wet with P800 - 1000 grade.



Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

Application.

Important note for the mixing system:



Stir Permafleet® Mixing Concentrates 600 well before weighing out.

After adding Permafleet® HS Binder Series 670, Permafleet® HS Top Coat 670 must be stirred thoroughly.

Mixing ratio:



3:1 by volume with
Permafleet® VHS Hardener 3265 fast
(small to medium-sized objects at 20 - 25°C)

Permafleet® VHS Hardener 3270
(medium-sized to large objects at 20 - 25°C)

Permafleet® VHS Hardener 3275 slow
(medium-sized to large objects at 30°C)

The mixing ratio 3:1 by volume is for high gloss colours only. Mix matt colours 5:1 by volume with Permafleet® VHS Hardeners and add 10% reducer to adjust viscosity ready for use.

Pot life:

Ready for use 2 - 3 hours at +20°C.
(depending on hardener used)

Reducer:

Permafleet® Reducer 6110 fast
(small objects at 15 - 25°C)





Permafleet® Reducer 6120
(medium-sized objects at 20 - 25°C)

Permafleet® Reducer 6130 slow
(large objects at 20 - 30°C)

Permafleet® Reducer 6140 extra slow
(large objects above 30°C)

Permafleet® Reducer 6150 SA for special applications
(airless, airmix, ESTA)

Method of application:

	Compliant	HVLP	Pressure pot	Membrane pump
				

Application viscosity
4 mm, +20°C, DIN 52311:



20 - 25 seconds

Reducer at +20°C material temperature:



10 - 15% (for details, see mixing formula or label)

Spray nozzle*:

1.4 - 1.6 mm

1.4 - 1.6 mm

0.8 - 1.3 mm

0.8 - 1.3 mm

Spray pressure*:

2.0 - 2.5 bar

-

3 - 4 bar

3 - 6 bar

Atomising pressure*:

-

0,7 bar

-

-

Material pressure*:

-

-

0.8 - 1.3 bar

-

Number of coats:

1 spray operation = 1 tack coat followed by 1 full coat (without flash-off between coats).
On objects which are difficult to paint, e.g. dropsides and tankers, it is possible to apply 2 coats with 5 - 10 minutes flash-off between coats.
With low-opacity colours, it may be necessary to apply one or two more coats after 10 minutes flash-off.

Recommended film thickness:




40 – 80 µm dry film thickness

Electrostatic application:

According to the advice of the Technical Consultant.

* See manufacturer's instructions!

Method of application:

	Airless	Airmix
	20 - 25 seconds	
	10 - 15% (for details, see mixing formula or label)	
	0.23 - 0.28 mm	0.23 - 0.28 mm
	160 - 250 bar	90 - 120 bar
	1 spray operation = 1 tack coat followed by 1 full coat (without flash-off between coats). On objects which are difficult to paint, e.g. dropsides and tankers, it is possible to apply 2 coats with 5-10 minutes flash-off between coats. With low-opacity colours, it may be necessary to apply one or two more coats after 10 minutes flash-off.	
	40 – 80 µm dry film thickness	
	According to the advice of the Technical Consultant.	

Application viscosity
4 mm, +20°C, DIN 52311:

Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Number of coats:

Recommended film thickness:

Electrostatic application:

Elastification of rigid and half-rigid types of plastic:

By addition of 15 - 20 % Permasolid® Elastic Additive 9050 to the base material the paint system gets a lasting elasticity. The mixing ratio with the mentioned hardeners remains unchanged.

Drying.

Air drying:



At +20°C ambient temperature

dust dry: 20 - 60 minutes
dry for handling: 4 - 6 hours
dry: overnight (16 hours)

Force drying:



Flash-off time:

5 - 10 minutes



Drying time and temperature:

30 - 40 minutes
at +60°C
metal temperature

* See manufacturer's instructions!

Data.

	Permafleet® HS Top Coat 670		Mixed with VHS Hardener 3270 +15% Reducer 6120	
	white	black	white	black
Viscosity as supplied:	75 - 85 sec.	110 - 120 sec.		
Flash point:	26°C	27°C		
Solids content:	73.0 % by weight	63.5 % by weight	64.3 % by weight	57.2 % by weight
	59.4 % by volume	59.6 % by volume	53.6 % by volume	53.7 % by volume
Specific weight:	1.31 g/cm ³	1.00 g/cm ³	1.20 g/cm ³	1.00 g/cm ³
Coverage*: at 50 µm dry film thickness:			10.7 m ² /l	10.8 m ² /l
VOC value: 2004/42/IIB(d)(420)420	The EU limit value for this product (product category IIB.d) in ready to use form is max. 420 g/litre of VOC.			
	The VOC content of this product in ready to use form is max. 420 g/l.			

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

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